

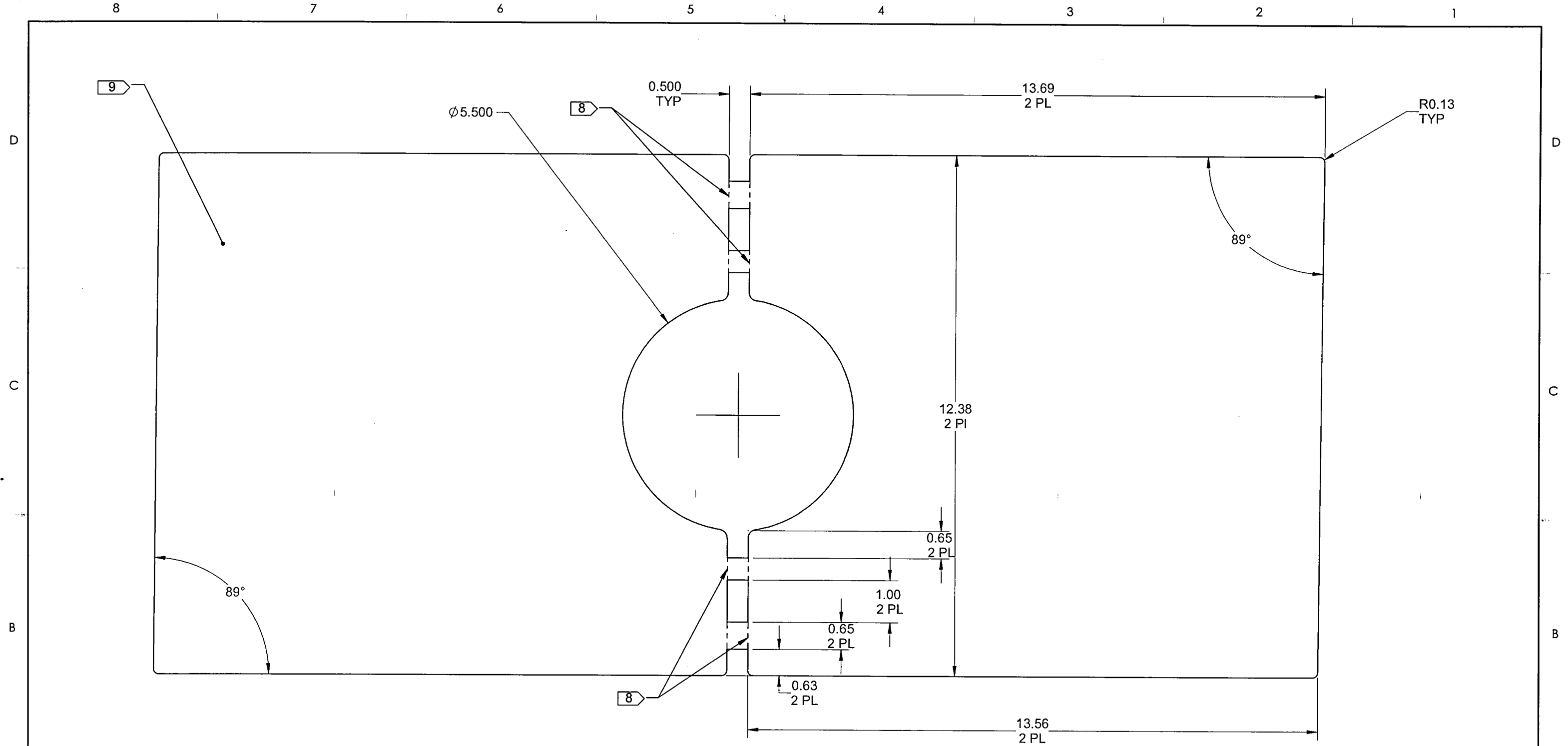
**D3609-1 DOUBLER**

**NOTES:**  
1) MATERIAL: MAKE FROM D3609-1F FLAT PATTERN  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
7) WEIGHT: 1.46 lbs  
8) FORM USING DT9763 AND TRIM PER PHANTOM LINE ON SHEET 2  
9) ORIENT MATERIAL WITH POLISHED SIDE (PLASTIC FILM) SHOWN AS INDICATED

RELEASED  
2017-09-28  
ECN 17-620

APPROVED

E	SHEET 1: ADD NOTE 9. SHEET 2: ADD "POLISHED" No. 4" TO NOTE 1 & ADD NOTE 9. REASON NCR17-6290	SAD	17.03.14
D	REVISE FLAT PATTERN SYMMETRY; R2.75 WAS R2.63 (ZN C6-2)	RF	11.09.20
C	2.88 WAS 2.98 (ZN C5-1); 3.03 WAS 3.20 (ZN C4-1); 0.53 WAS 0.50 (ZN D4-1); ADD ANGLE TOLERANCE (ZNC3-1); REVISE D3609-1F	RF	11.06.07
B	ADD BEVEL (ZN C3-1); ADD FLAT PATTERN (ZN B4-2)	RF	11.04.28
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3609	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	CP	DOUBLER	NTS
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**D3609-1F FLAT PATTERN**  
(FLAT PATTERN)  
(MAKES 2 PARTS)

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED, 22 GAUGE, POLISHED No. 4  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC M304S22GA4P
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.93 lbs
- 8) FORM USING DT9763 AND TRIM PER PHANTOM LINE
- 9) ORIENT MATERIAL WITH POLISHED SIDE (PLASTIC FILM) SHOWN AS INDICATED

RELEASED  
2017-09-28

APPROVED

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	DD	<b>D3609</b>	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	CP	<b>DOUBLER</b>	NTS
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